

Date: Thursday, 25/10/2007 2:34:52 PM
User: Linda Lacelle

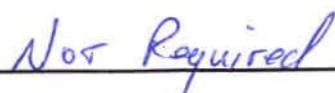
ASAP

Dart Aerospace Ltd.

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SHAFT SLEEVE	(4)	
Job Number	: 35400	Part Number	: D32337		
Estimate Number	: 11155	Drawing Number	: D3233 REV B		
P.O. Number	: N/A	Project Number	: N/A		
This Issue	: 25/10/2007	Drawing Revision	: B		
Prsht Rev.	: NC	Material	: N/A		
First Issue	: N/A	Due Date	: 01/11/2007		
Previous Run	: 28618	Qty:	14		Um:
Written By	:				
Checked & Approved By	:				
Comment	: Est. A 05.03.14 New issue KJ/JLM				

Additional Product

Job Number:		
Seq. #:	Machine Or Operation:	Description :
1.0	M1020TR1375W125	COLD DRAWN ROUND TUBE
		
Comment: Qty.: 0.1860 f(s)/Unit Total : 2.6034 f(s) 1020-1025 Round Tube Material: AISI 1020-1025 Seamless Round Tubing Cold Drawn per MIL-T-5066 or ASTM A513-00 MT1020 SRA or AMS 5075 or AMS 5077 (M1020TR1.375W.125) Identify for D3233-7 Batch: <u>M103258</u>  07/10/25		
2.0	LATHE CONV.	CONVENTIONAL LATHE
		
Comment: CONV.LATHE Turn as per Dwg D3233  07/10/25 4		
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
		
Comment: INSPECT PARTS AS THEY COME OFF MACHINE  07/10/26 4		
4.0	QC8	SECOND CHECK
		
Comment: SECOND CHECK  07.10.26 4		
5.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
		
Comment: CONVENTIONAL MILLING MACHINE Deburr 		

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SHAFT SLEEVE

Job Number: 35400

Part Number: D32337

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

5 09/10/26

7.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: WS23

CARL

(4)



8.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE



D09/10/27 (4)

Job Completion



W 09/10/29

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. B
		D3233	SHEET 3 OF 3

DATE

05.03.08

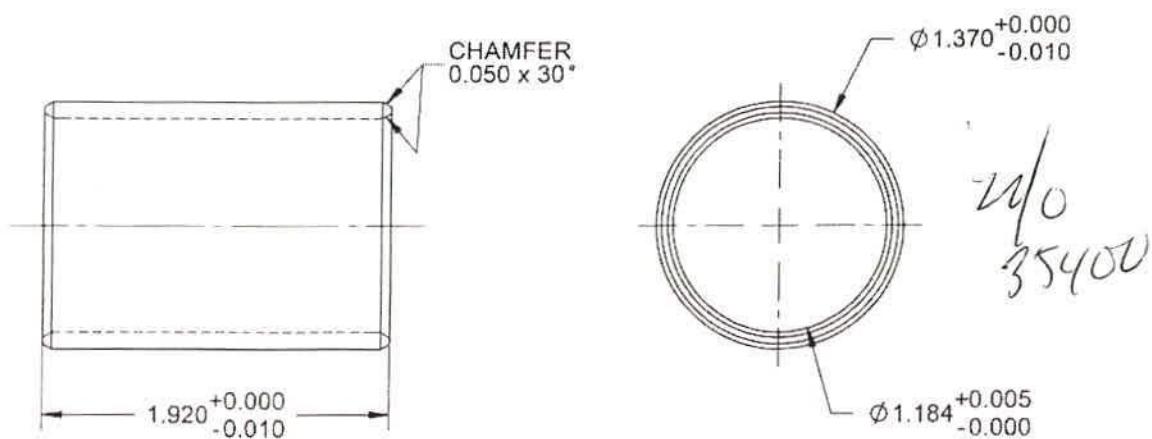
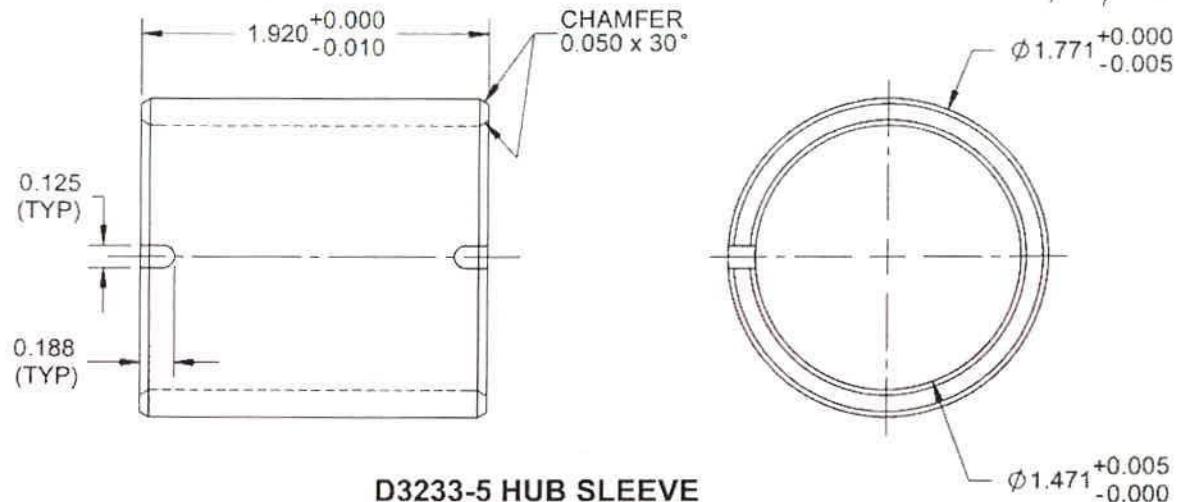
TITLE

WHEEL ASSEMBLY

SCALE

1:1

RELEASED
AB
05/05/04

**NOTES:**

- 1) MATERIAL: AISI 1020-1025 ROUND TUBING PER MIL-T-5066 OR ASTM A513-00
MT1020 SRA OR AMS 5075 OR AMS 5077, COLD DRAWN, SEAMLESS
(REF. DART SPEC. M1020TR)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.030

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DART AEROSPACE LTD	Work Order:	35400
Description: Crosstube Assembly	Part Number:	D3233-7
Inspection Dwg: D3233	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

First Article Prototype

Measured by:	<u>JH</u>	Audited by:	<u>J.F.</u>	Prototype Approval:	N/A
Date:	<u>07/10/26</u>	Date:	<u>07/10/26</u>	Date:	N/A
Rev	Date	Change		Revised by	Approved
A		New Issue		KJ/JLM	